

Date: Monday, 7/9/2007 11:39:50 AM
 User: Kim Johnston

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP (CASTING DETAIL)		
Job Number	: 33321 ~ 1			Part Number	: D25763		
Estimate Number	: 10510			Drawing Number	: D2576 REV E1A G		
P.O. Number	:			Project Number	: N/A		
This Issue	: 7/9/2007	S.O. No.	:	Drawing Revision	: E1A G		
Prsht Rev.	: NC			Material	:		
First Issue	: 7/6/2007	Type	: PURCHASED PARTS	Due Date	: 7/24/2007		
Previous Run	: 31925			Qty:	100	Um:	Each
Written By	:			Handwritten signature			
Checked & Approved By	:			Handwritten signature			
Comment	: Est: E 02.08.19 Consolidated D2576-1 and D2576-3 KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D25761	Step (Casting Detail)
Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) Pick: Qty Part# Description Batch 1 D2576-1 Step (Casting Detail) <i>B 53320</i> <i>BC 08-01-30</i> <i>100</i>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS1 1- Machine as per Folio FA332 and Dwg D2576 2- Deburr <i>8.F 08-01/31</i> <i>BC 08-01-30</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>BC 08-01-30</i> <i>8.F 08/01/31</i>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>J.L 08/01/31</i>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>LG</i> <i>BC 08/01/31</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 150 Date: 08/02/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:39:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP (CASTING DETAIL)

Job Number: 33321

Part Number: D25763

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(25)

Comment: FINAL INSPECTION/W/O RELEASE

DD 08/02/01

Job Completion



mm 2005/1/31

(25)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Step	Part Number:	D2576-3
Inspection Dwg: D2576	Rev: E1F G	Page 1 of 1

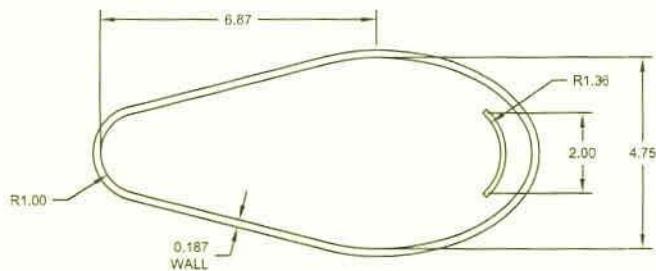
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

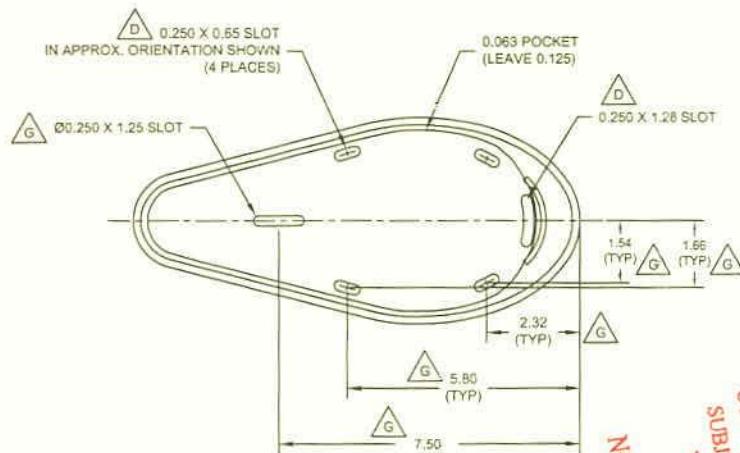
Measured by:	<i>BC</i> <i>JL.F</i>	Audited by:	<i>Ang</i>	Prototype Approval:	N/A
Date:	08.01.30/31	Date:	08/01/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.10	New Issue	KJ/RF <i>✓</i>	FF

8 7 6 5 4 3 2 1



D2576-1 CASTING

D2576-3 MACHINING DETAIL
(MAKE FROM D2576-1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33321

NOTES:

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

8 7 6 5 4 3 2 1

RELEASED

07.08.15

REV.	DESCRIPTION	BY	DATE
G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	99.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18
DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>PH</i>	D2576	SHEET 1 OF 1
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	STEP	1:3
DATE	07.08.15	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

